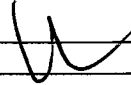


ASAP

Dart Aerospace Ltd.

Date: Tuesday, 24/03/2009 3:32:26 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 46681	
Estimate Number : 11030	
P.O. Number :	Part Number : D2803042
This Issue : 24/03/2009 S.O. No. :	Drawing Number : D2803 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 46330	Material :
Written By : 	Due Date : 30/03/2009 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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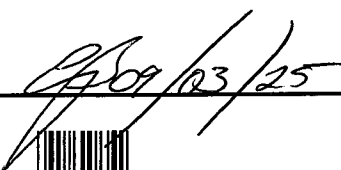
1.0	D28032	Bracket
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-2	Bracket	B44478



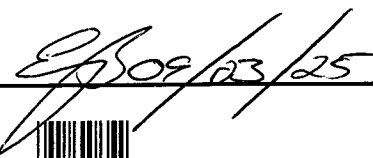
2.0	D28052	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	B46314



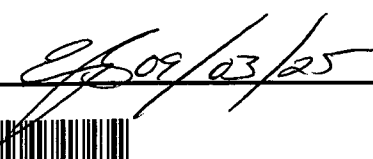
3.0	D2809	Bushing
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B40929

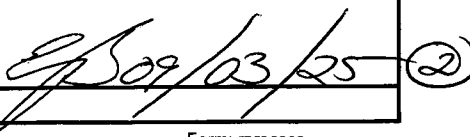


4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/03/2009 3:32:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46681

Part Number: D2803042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 02/03/25 (2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 3:20

OVEN TEMPERATURE: 320°

FINISH TIME: 3:50

FL 09/03/25 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-27 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2809 into arm as per Dwg D2803

EP 09/03/30 (2)

9.0

AN3C16A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3C16A Bolt

M1109147

EP 09/03/30

10.0

MS210433

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch

2 MS21043-3 Nut

M110562

EP 09/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/03/2009 3:32:26 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46681

Part Number: D2803042

Job Number:



Seq. #: Machine Or Operation: Description :

11.0 NAS1515H3 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

* Qty Part Number Description Batch
4 NAS1515H3 Washer M109268
A/R LPS-3 Corrosion Spray M109929
Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803

EP 09/03/30

12.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

EP 09/03/30 (2)

13.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/03/30 (2)

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 149

9/3/30

(2K)

Seq

15.0 QC21 FINAL INSPECTION/W/O RELEASE



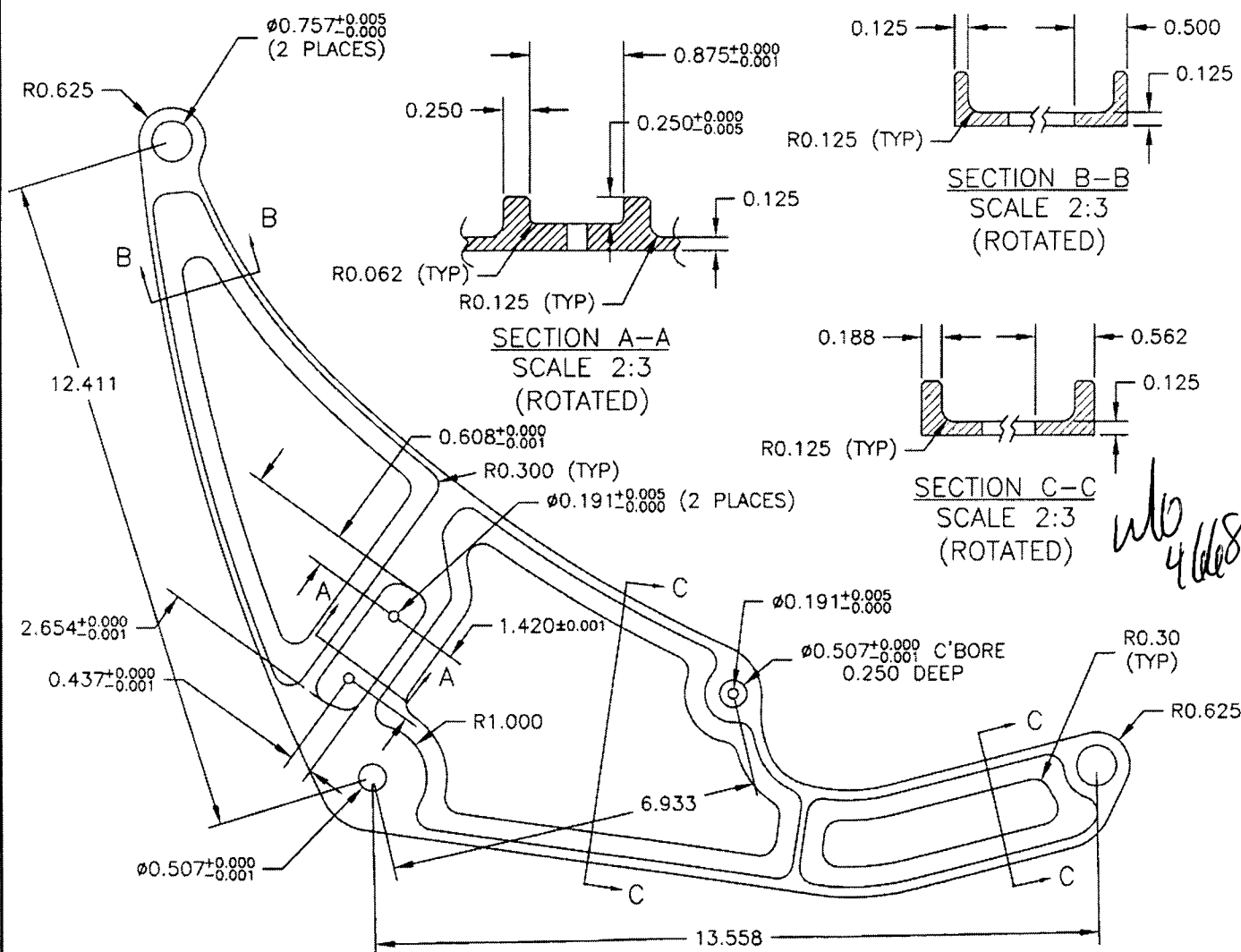
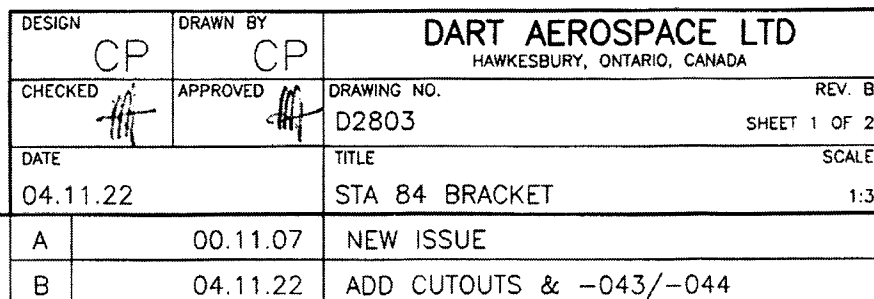
Comment: FINAL INSPECTION/W/O RELEASE

09/04/01

Job Completion



mf
09-03-31

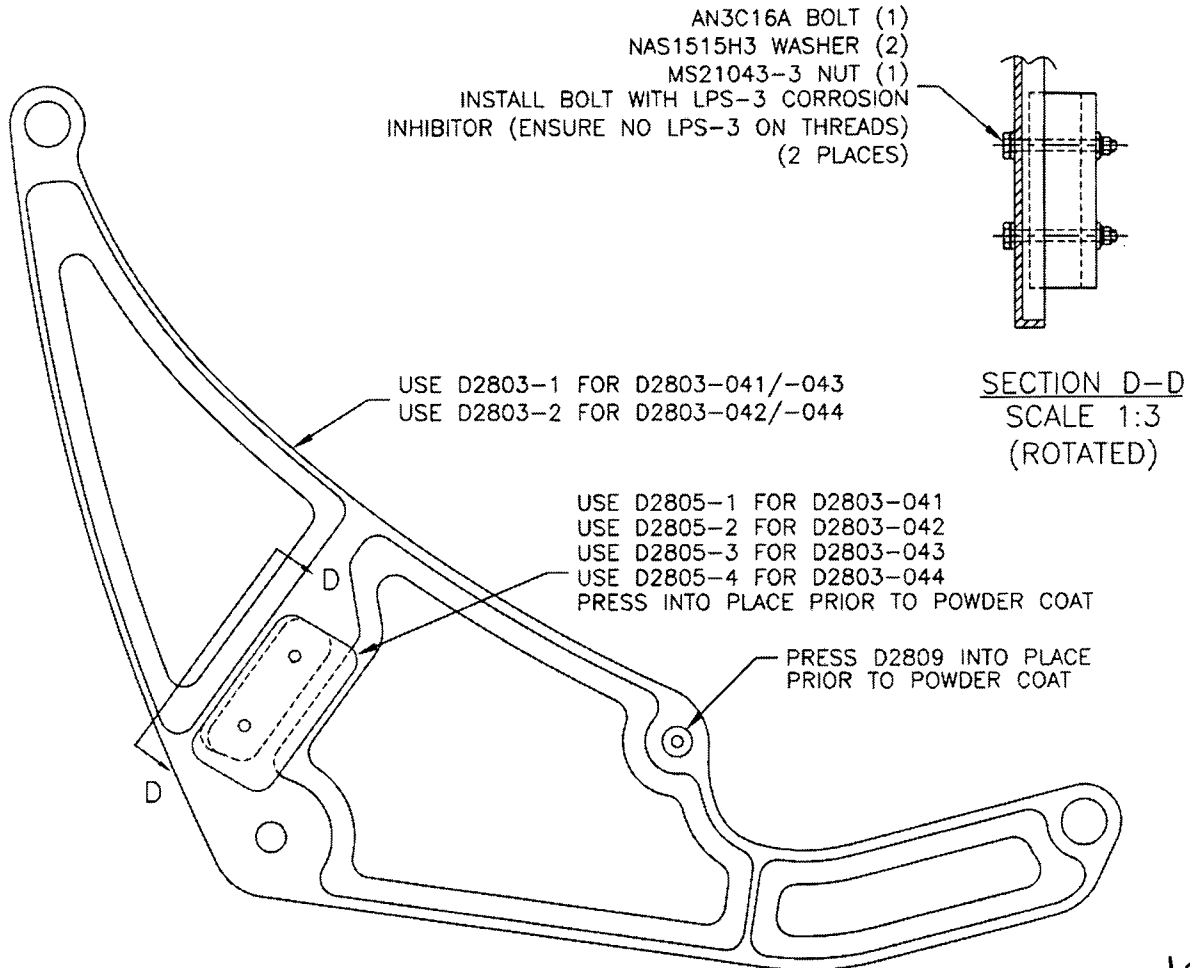


- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D2803	SHEET 2 OF 2
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3



RELEASED

05.03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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